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Dart Aerospace Ltd.
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D3913-041
Job Sheet 199701



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/29/19

Job Tracking No:

Due Date: 10/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Large Fab - Basket - 1	1 pcs		10/15/19	0.00	19.61	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		MAL
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs		10/15/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs		10/15/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		



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Container No: S220955



Part: D3913-041

Job No: 199701

Serial No/Batch: S220955

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/08/19

Plex 8/29/19 11:51 AM Dart.lajeunesse.marie

						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
125	Handfinish - 2-1 Pressure-B4B	1 pcs	10/15/19	0.00	0.29	Handfinish - 2 - 1 - B4B	BEB 19-10-10
						Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	
						Handfinish - 2 - 4 - B4B	
130	Powdercoat - 2 White Gl(S)-B4B	1 pcs	10/15/19	0.00	0.93	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BL 19-10-10
						Powdercoat - 4 - B4B	
140	QC 3	1 pcs	10/15/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	BEB 19-10-11
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
150	Handfinish - 4-1-Assembly-B4B	1 pcs	10/15/19	0.00	0.50	Handfinish - 4 - 1 - B4B	
						Handfinish - 4 - 10 - B4B	BEB 19-10-11
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	

160 QC 5	1 pcs	10/15/19	0.00	0.00	Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
170 Packaging 3-1 - Stock - B4B	1 pcs	10/15/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	

DAS
81
9-89

OCT 11 2019

BEB19-10-11

				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	1	10/15/19	0.00 0.00	QC 21 - SA - 21	DAS 21
	pcs			QC 21 - SA - 70	9-89 OCT 11 2019
				QC 21 - SA - 53	
Part Op 100 - Weld per dwg A/R S.S. rod Batch <u>1139015</u> 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ****take lid to locate hinge and bracket*** 4- Weld D4672-1 blanking plates as per dwg 110 - QC9- Inspect visual per QSI004- Fusion Welds 120 - QC5- Inspect part completeness to step on W/O 125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings 130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder coat 140 - QC3- Inspect Part Finish 150 - Assemble as per dwg - Pick Kit 160 - QC5- Inspect part completeness to step on W/O 170 - Identify as per dwg & Stock Location: _____ 180 - QC21- Final Inspection - Work Order Release					

MU # 012175

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5211240
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5215071
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5189576
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5209250
D3913-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5214637
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5210802
D3916-041	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	5214262
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5217493
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	5213575
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	1x516871/1x5167884/1x5210014
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5214695
D4020-11	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5212813
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	5210384
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5216390
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5216456
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	5210714
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	5206462
AN3-10A	BOLT	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5212401-1
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	FR6435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5196544.5202574
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5214283-2
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	5207709
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5188988
NAS1149FN832P	Washer (AN960-8)	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5136368

m.u.#012376

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	41	0
	D3913-1	1	11	0
	D3913-15	1	17	0
	D3913-3	1	15	0
	D3913-7	2	12	0
	D3913-9	1	6	0
	D3916-041	2	2	0
	D3916-5	3	19	0
	D4016-1	3	19	0
	D4017-7	3	31	0
	D4017-9	2	8	0
	D4020-11	2	8	0
	D4021-1	3	19	0
	D4034-041	1	4	0
	D4034-043	1	5	0
	D4672-1	2	1	0
	M304EX0.75-16F	32	1,051	0
150-Handfinish - 4-1-Assembly-B4B	AN3-10A	6	180	0
	D2931	2	677	0
	D4021-5	2	24	0
	MS20600-AD4W3	2	448	0
	MS21042L3	6	1,476	0
	NAS1149F0332P	12	2,802	0
	NAS1149FN832P	2	2,457	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION			DEPARTMENT/PROCESS									
		Rework ☐ Scrap ☐ Use-as-is ☐			Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)										
Description Work Order Deviation				Disposition										
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY										
				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐				
				Other/Details: _____										
				Completed By _____										
				Lead hand / Supervisor _____										
				QC / QA Coordinator _____										